

Date: Monday, 2/19/2007 8:07:48 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 30752
 Estimate Number : 12729
 P.O. Number : N/A
 This Issue : 2/19/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : N/A
 Written By : [Signature]
 Checked & Approved By : [Signature] 07.02.14
 Comment : Est Rev: A New Issue 07-02-15 JLM

Drawing Name : WEARSHOE
 Part Number : D353539
 Drawing Number : D3535 UNDER REVIEW ^{Rev A} _{PH 07.02.19}
 Project Number : N/A
 Drawing Revision : U/R
 Material : N/A
 Due Date : 2/26/2007 Qty: 12 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 0.9986 sf(s)/Unit Total : 11.9826 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: M101873

SAO 07/02/25

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3535
 Dwg Rev: A
 Prog Rev: A

SAO 07/02/25

2-Deburr if necessary

(12)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAO 07/02/25

12

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAO 07.02.25

12

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Deburr if necessary
 Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.
 Identify as D3535-41
 Form Joggle on brake using Jig DT8158 as per Dwg D3535

SA MF 07-03-06

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:07:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 30752

Part Number: D353539

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/07 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

HS | M-A 07-03-07 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

R.M 07/03/07 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: FP

HS 07-03-08 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/08

Job Completion



U 07-03-08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

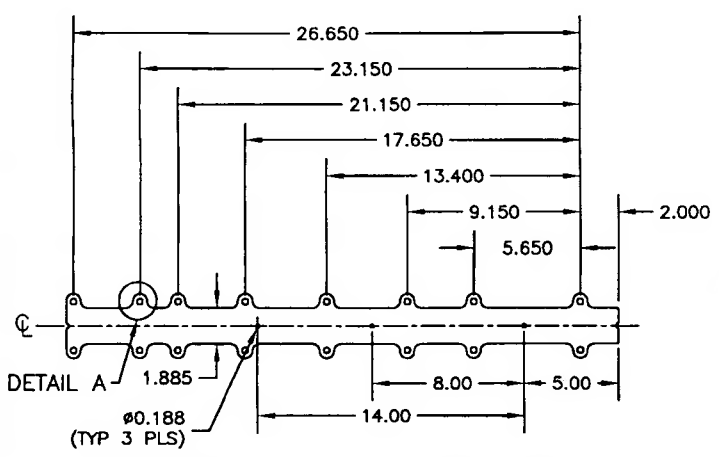
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

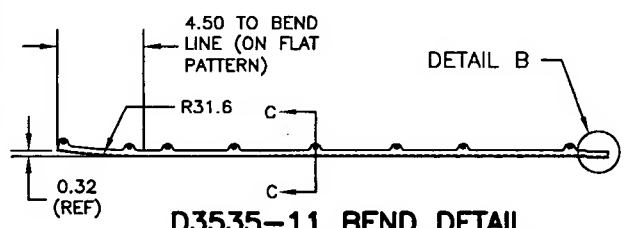
DART

RELEASED
07.02.12

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3535	REV. A
		TITLE	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE		SCALE 1:10

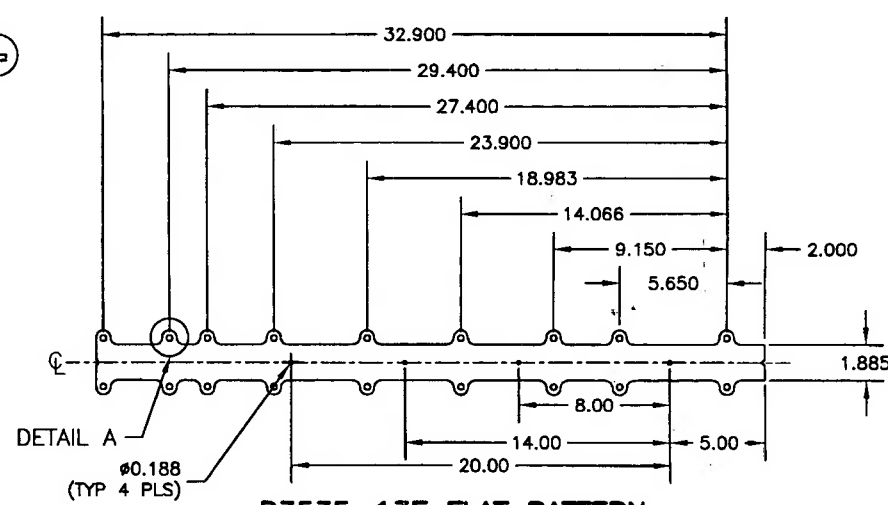


D3535-11F FLAT PATTERN

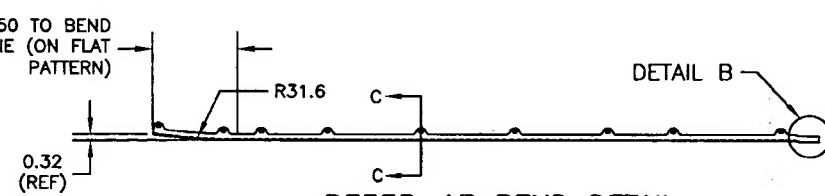


D3535-11 BEND DETAIL

NO. 30752
WORK ORDER
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D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

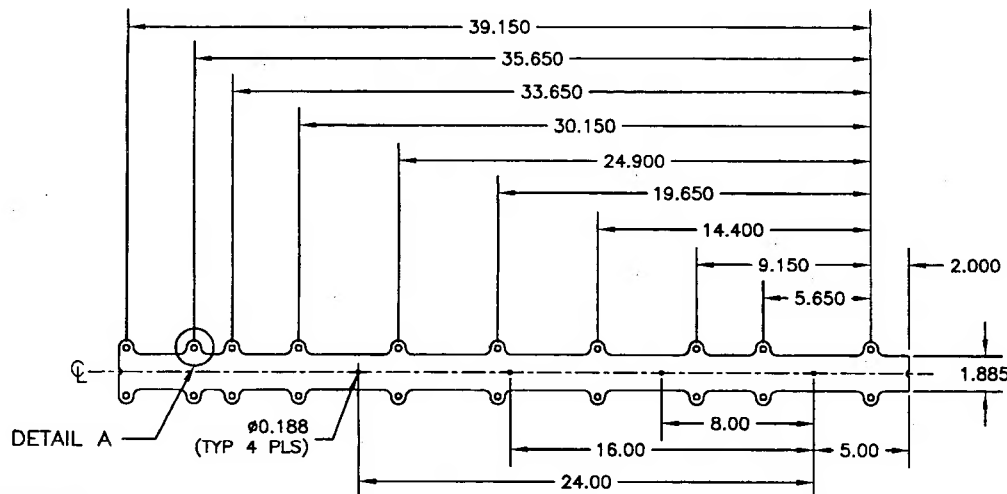
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

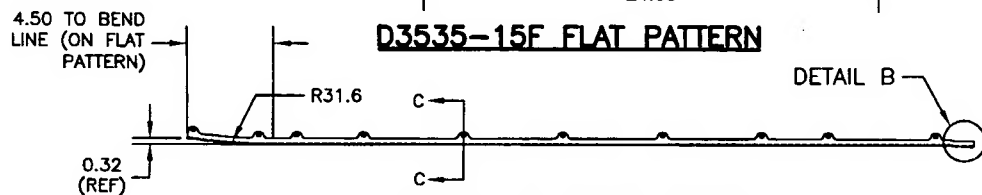
DART

DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3535	REV. A
		TITLE	WEARSHOE	SHEET 2 OF 7
				SCALE 1:10

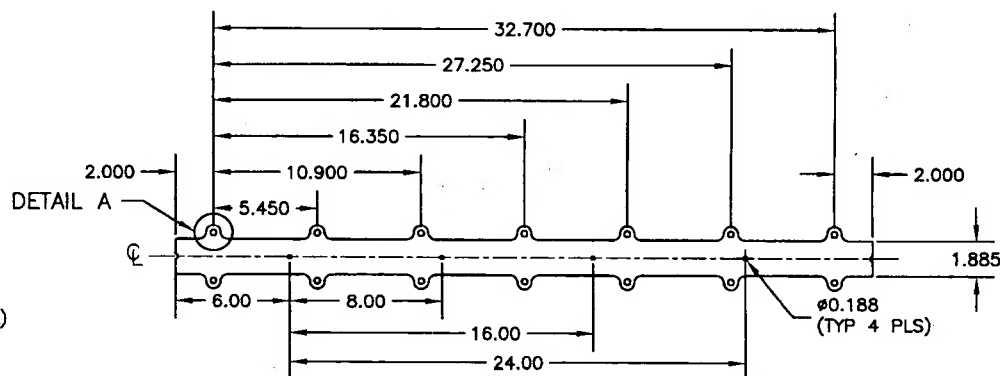
07.02.12



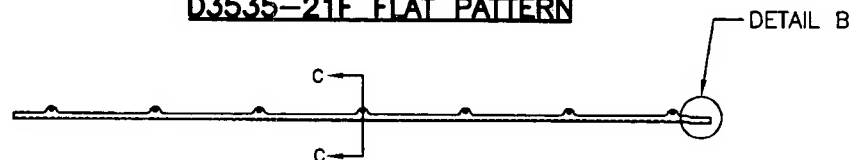
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

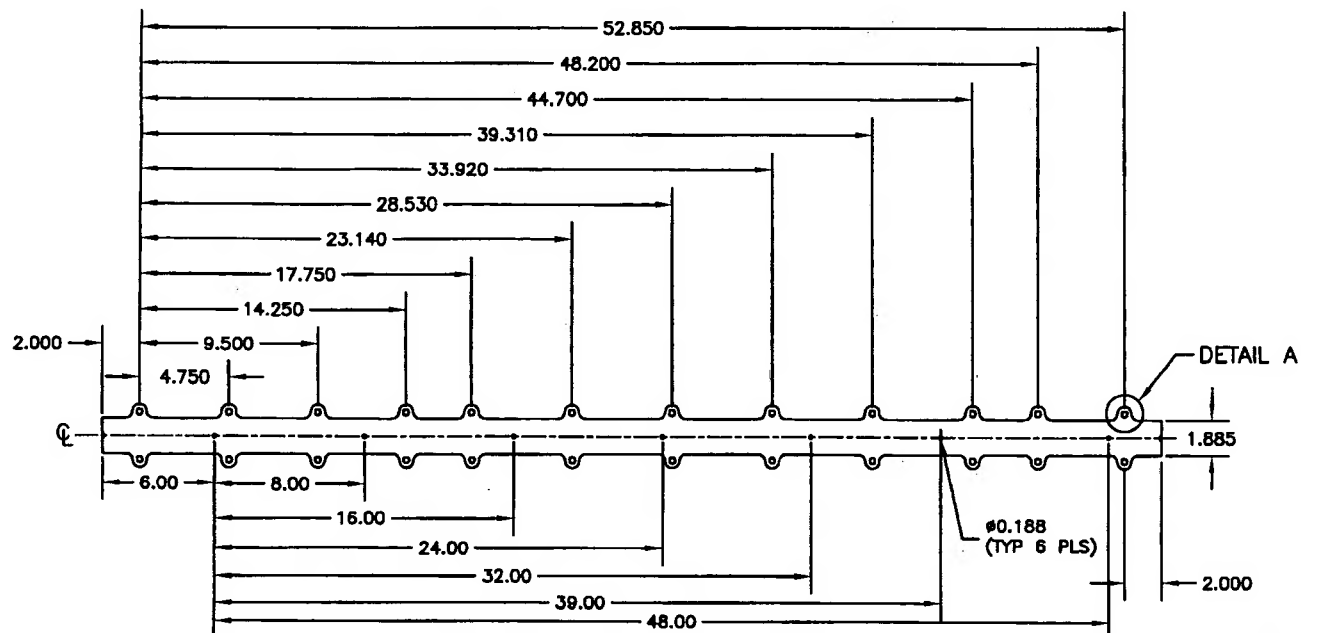
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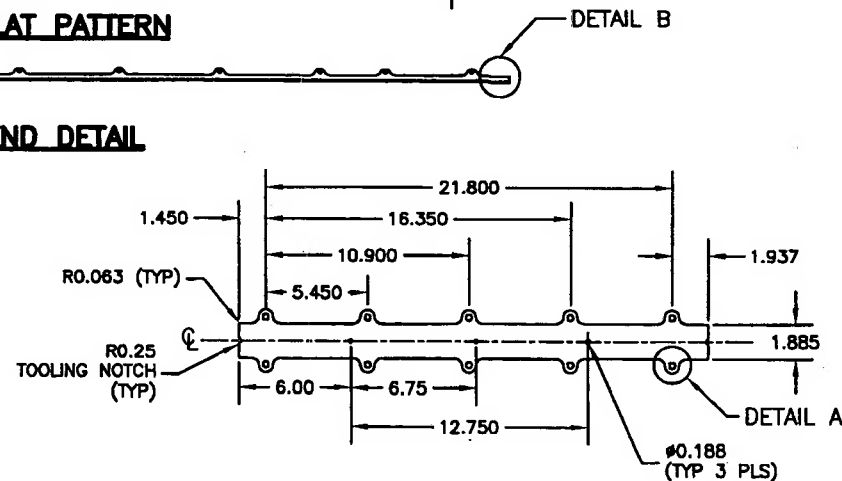
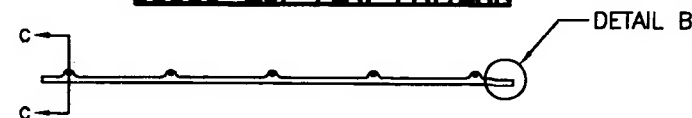
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DATE	06.10.25	TITLE	D3535	WEARSHOE	SHEET 3 OF 7
		SCALE	1:10		

**D3535-23F FLAT PATTERN**

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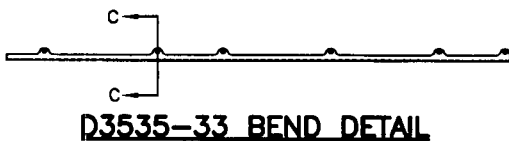
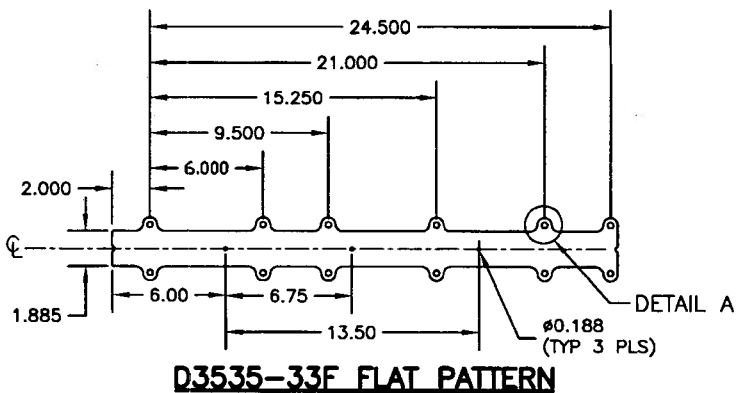
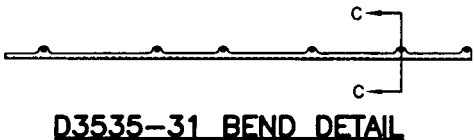
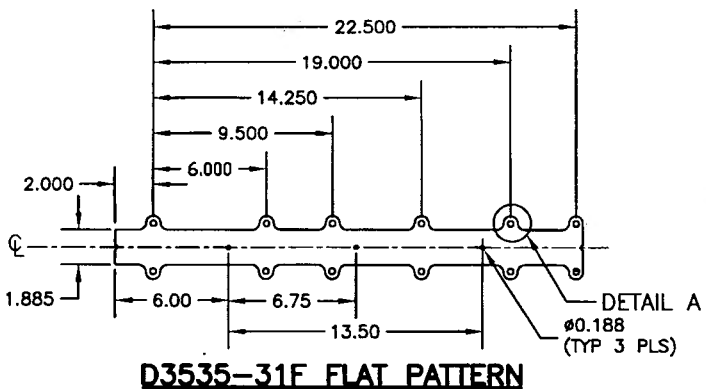
D3535-23 BEND DETAIL**D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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DATE	06.10.25	TITLE	D3535	WEARSHOE
		SCALE	1:10	
		SHEET 4 OF 7		
		REV. A		

07.02.12 CH



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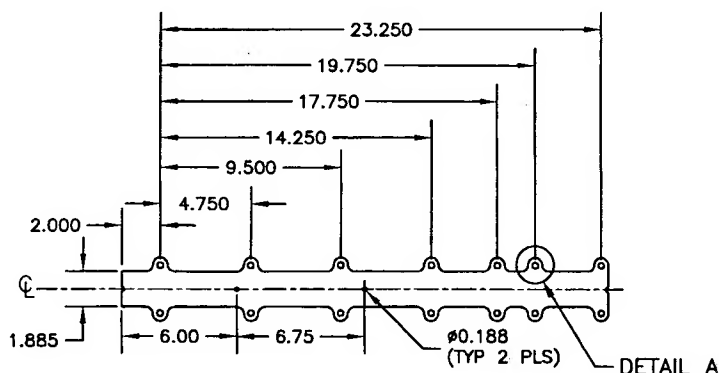
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DATE	06.10.25	DRAWING NO.	D3535	REV. A
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	

070212 CH



D3535-35F FLAT PATTERN

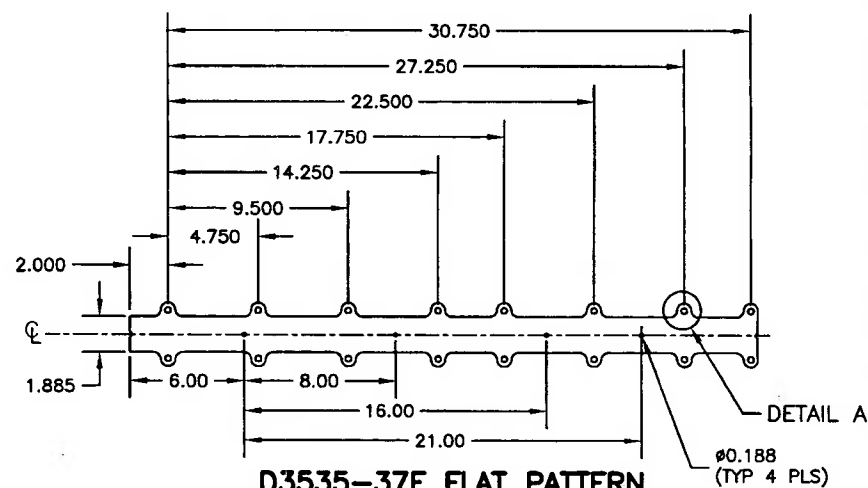


D3535-35 BEND DETAIL

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NOTES

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D3535-37F FLAT PATTERN

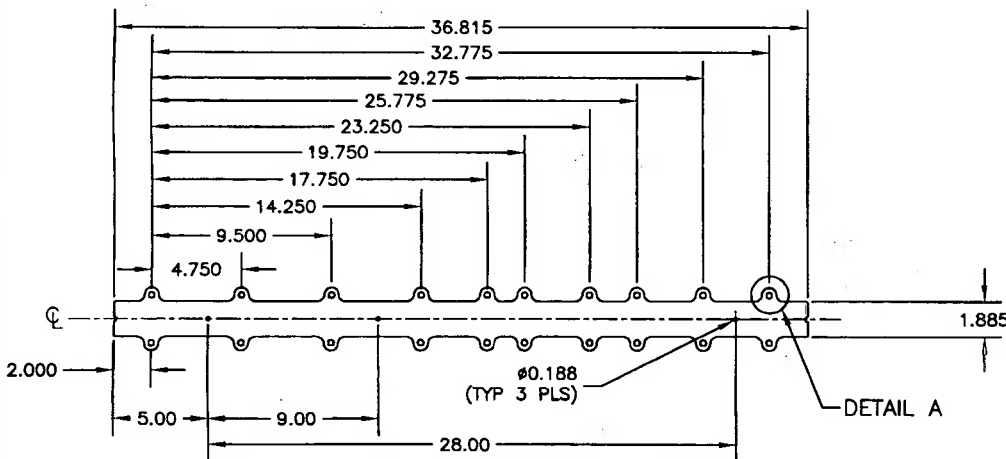


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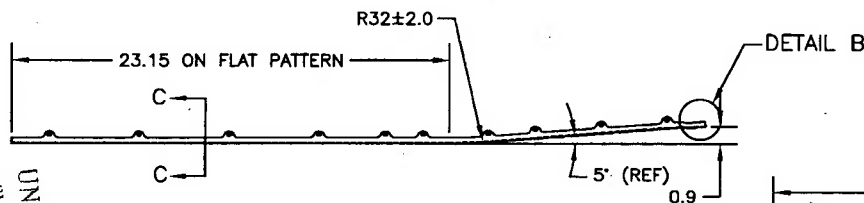
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DATE	06.10.25	TITLE	D3535	DRAWING NO.	REV. A
			WEARSHOE	SHEET 6 OF 7	SCALE
					1:10

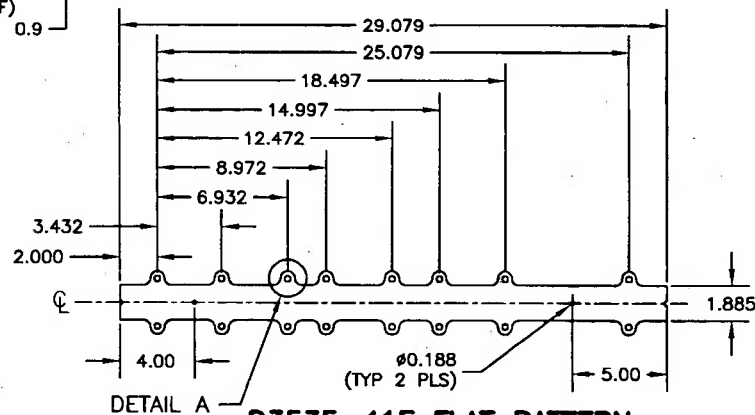
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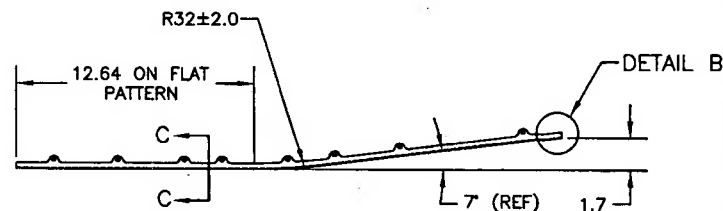
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
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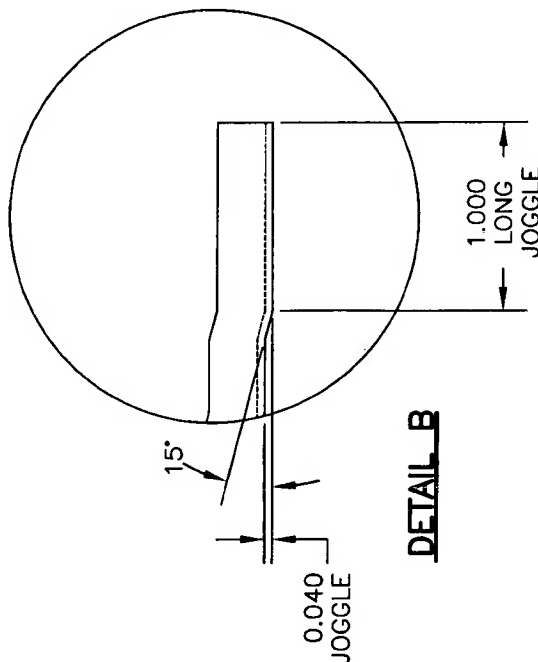
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WORK ORDER
30752

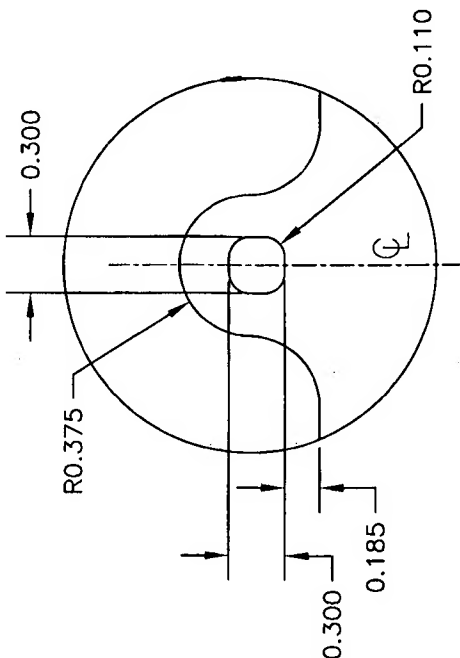


DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. A SHEET 7 OF 7
DATE 06.10.25	TITLE WEARSHOE		SCALE 1:1

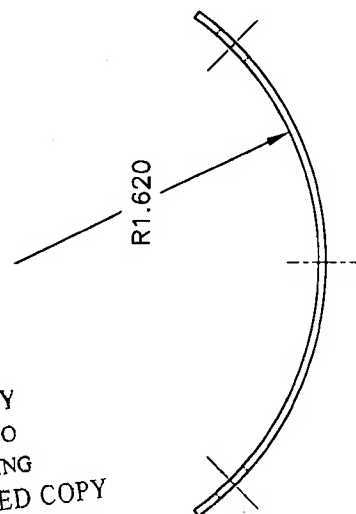
07.02.12 *[Signature]*



DETAIL B



DETAIL A



SECTION C-C

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WORK ORDER
NO. **30752**

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DART AEROSPACE LTD		Work Order: 30752
Description:		Part Number: D8535-39
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.750	± 0.010	4.744	✓		Vern	
9.500	± 0.010	9.500	✓		Vern	
14.250	± 0.010	14.250	✓		M-T	
17.750	± 0.010	17.750	✓		M-T	
19.250	± 0.010	19.790	✓		M-T	
23.250	± 0.010	23.250	✓		M-T	
25.775	± 0.010	25.775	✓		M-T	
29.275	± 0.010	29.275	✓		M-T	
32.775	± 0.010	32.775	✓		M-T	
36.815	± 0.010	36.806	✓		M-T / Vern	
2.000	± 0.010	2.000	✓		Vertical Vern	
5.00	± 0.030	5.000	✓		Vern	
9.00	± 0.030	9.000	✓		Vertical Vern	
28.00	± 0.030	28.00	✓		M-T	
1.885	± 0.010	1.888	✓		Vern	
0.188	± 0.005	0.191	✓		Vern	
0.300	± 0.010	0.297	✓		Vern	
0.300	± 0.010	0.295	✓		Vern	
0.038	± 0.010	0.035	✓		Vern	

Measured by: JAV	Audited by: [Signature]	Prototype Approval:
Date: 07/02/25	Date: 07-02-25	Date:
Rev A	Date	Change
		New Issue
	Revised by: KJ/JLM	Approved: